

Date: Monday, 2/5/2007 8:07:19 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BAR
 Job Number : 30602
 Estimate Number : 10388
 P.O. Number : *N/A*
 This Issue : 2/5/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 28141
 Part Number : D31963
 Drawing Number : D3196 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : U/R
 Material : *N/A*
 Due Date : 2/9/2007 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : *J.F. 07.02.06*
 Comment : Est Rev: A New Issue 05-11-08 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X01500 6061-T6 Bar .75" X 1.5"



Comment: Qty.: 3.0345 f(s)/Unit Total : 24.2760 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)
 (M6061T6B0.750x01.500)
 Identify for D3196-3
 Batch: *M 103321*

J.F. 07/02/26

⑧

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank: (0.75" x 1.50") x 34.750" long Bar

J.F. 07/02/26

⑧

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3196-3 as per Folio FA339 and Dwg D3196 Identify as D3196-3

2-Deburr

J.F. 07/02/26

⑧

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/02/26

⑧

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L. 07/02/27

⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/26	3	1 piece The origine is shift 1040" on the x axes. So the dim. 987" is 1,826 on one side and 1,948 on the other.	CP 07.02.26 pr QSI 042	Dimension does not affect Stress report. Acceptable	J.F. 07/02/26	07-02-26	CP 07.02.26 pr QSI 042	07-02-26
07/02/26	3	one C' sink is 1040" to wide. 1 piece.	CP 07.02.26 pr QSI 042	Dimension does not affect Stress report. Acceptable	J.F. 07/02/26	07-02-26	CP 07.02.26 pr QSI 042	07-02-26

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:07:19 AM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 30602

Part Number: D31963

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YL

07/02/27 X8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

YL

07/02/28 X8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/3/02 8

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/3/02 PC

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/05

Job Completion



U 07.03.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 30602
Description: Bar		Part Number: D3196-3
Inspection Dwg: D3196	Rev: BC 04.02.06	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.627	✓			
33.650	+/-0.005	33.650	✓			
0.488	+/-0.005	.487"	✓			
17.011	+/-0.010	17.011"	✓			
0.512	+/-0.005	.510"	✓			
1.500	+/-0.010	1.501"	✓			
0.464	+/-0.010	.465"	✓			
0.504	+/-0.010	.506"	✓			
Ø0.344	+0.006/-0.001	Ø.348"	✓			
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	Ø.660"	✓			
0.962	+/-0.005	.961"	✓			
0.750	+/-0.010	.747"	✓			
4.750	+/-0.010	4.750"	✓			
12.531	+/-0.010	12.531"	✓			
16.999	+/-0.010	16.999"	✓			
21.844	+/-0.010	21.844"	✓			
29.625	+/-0.010	29.625"	✓			
0.250	+/-0.010	.250"	✓			
1.000	+/-0.010	1.000"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.987	+/-0.010	.986"	✓			
0.060 x 45°	+/-0.010 x 0.5°	.055 x 45°	✓			

Measured by: J.F.
Date: 07/02/26

Audited by: SD
Date: 04.02.26

Prototype Approval: N/A
Date: N/A

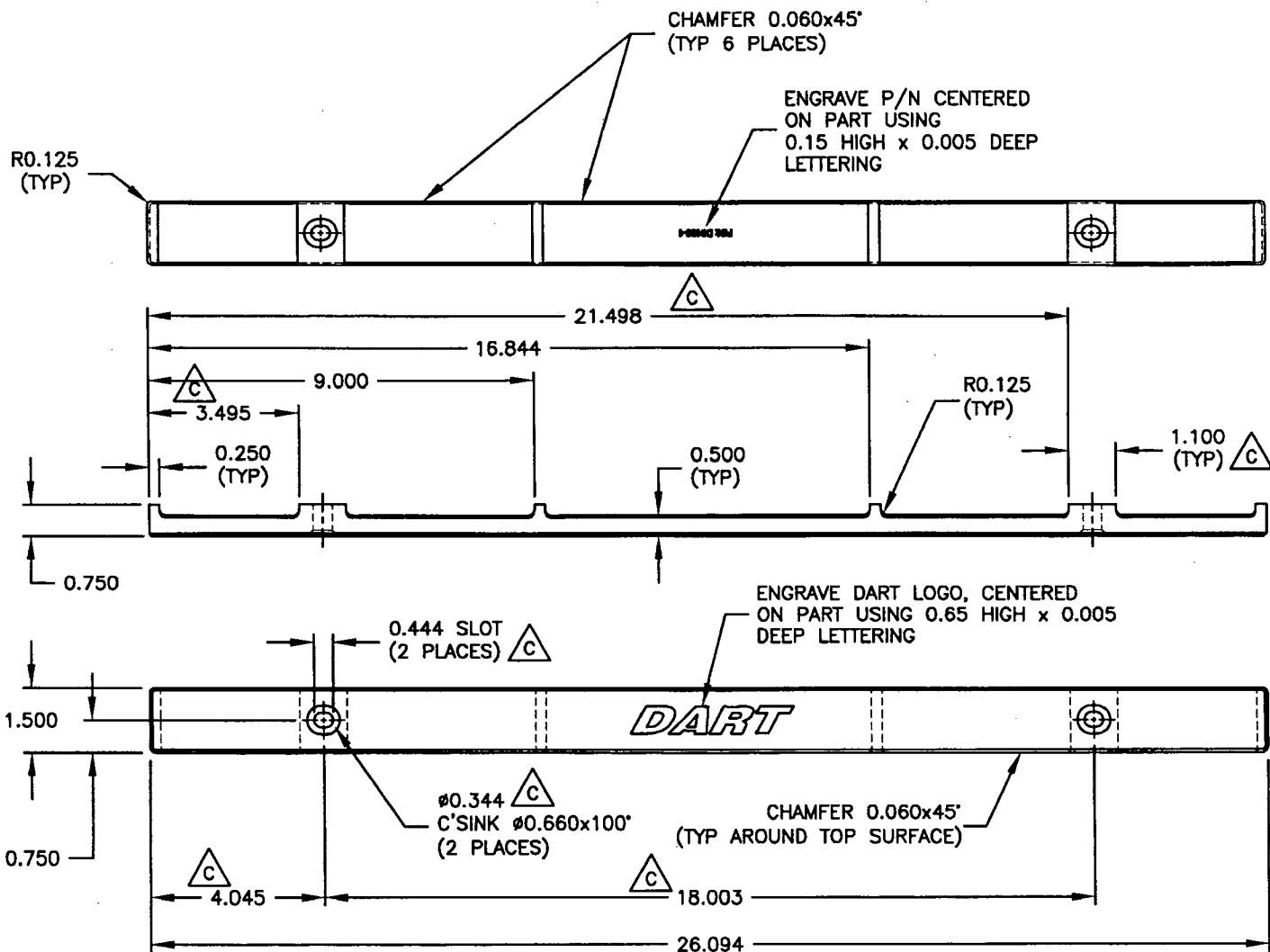
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM	BE

DART

RELEASED

06.10.31

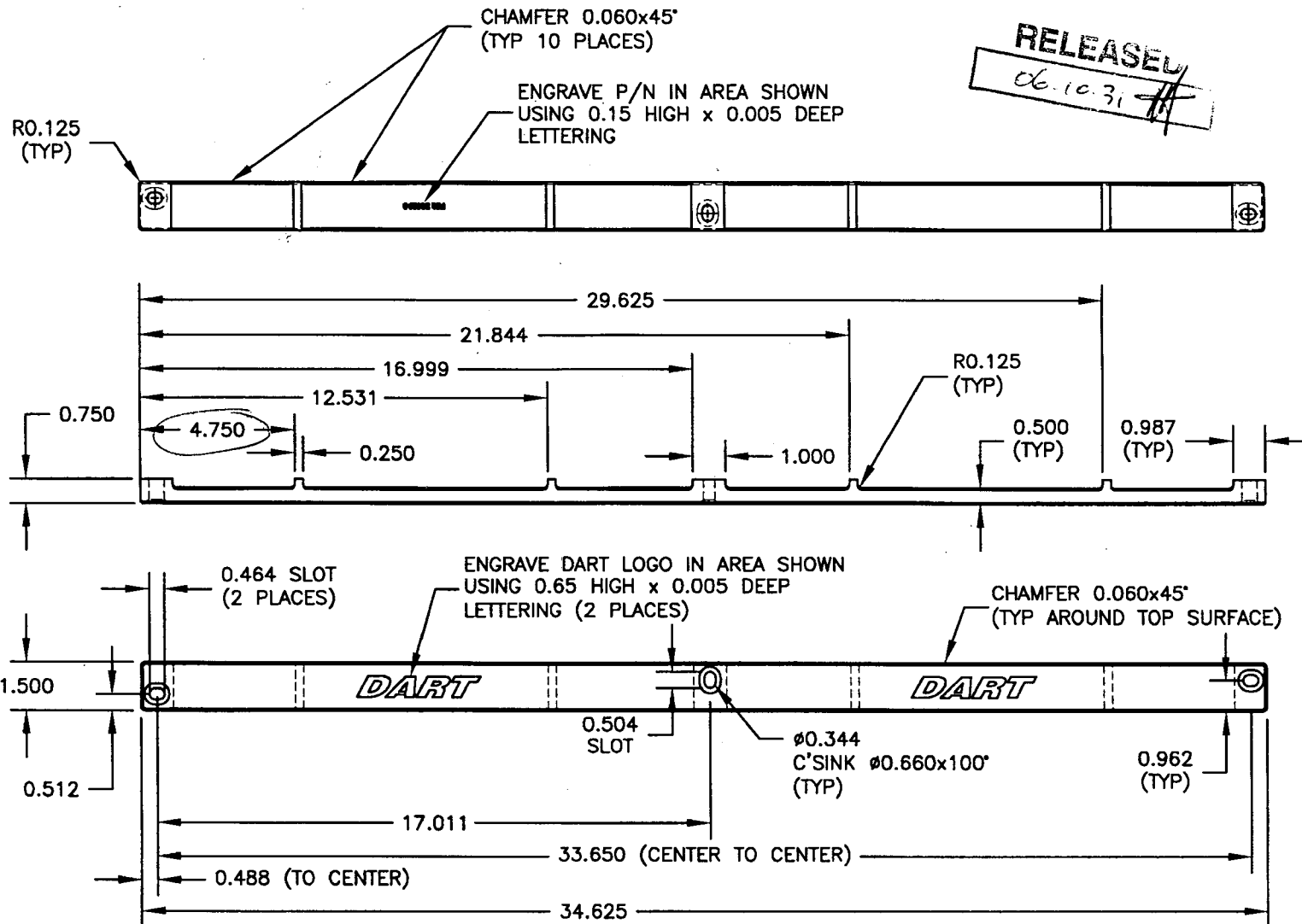
DESIGN	DRAWN BY	DART AEROSPACE LTD
00	00	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
00	00	D3196
DATE	TITLE	REV. C
06.10.31	BAR	SHEET 1 OF 3
A	03.06.25	NEW ISSUE
B	06.09.25	ADD D3196-5
C	06.10.31	ADD SLOTS ON -1; REMOVED -5



D3196-1 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 30602



D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

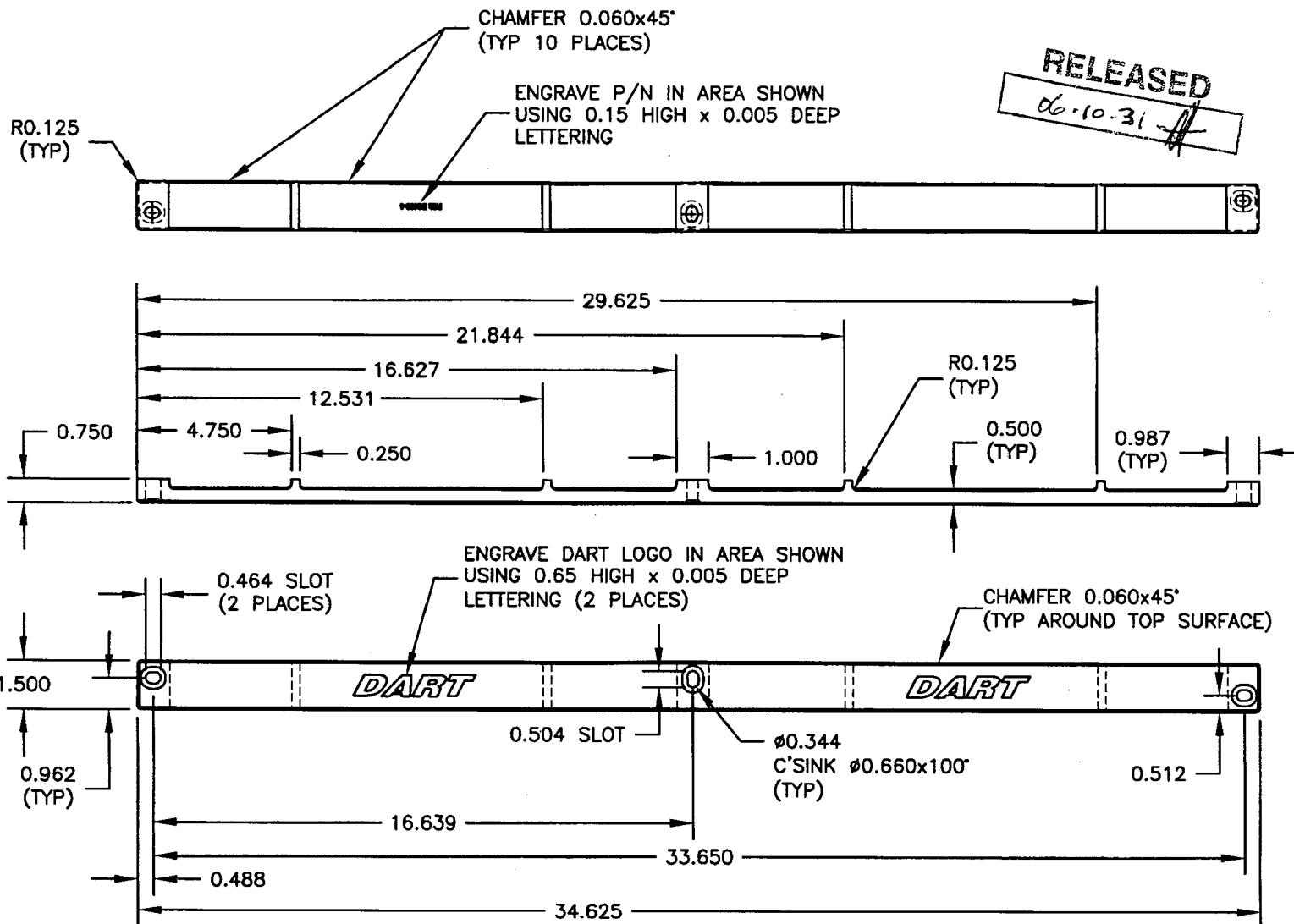
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RELEASED
06.10.31

DART

DESIGN	APPROVED	DRAWING NO.	REV. C
CHECKED	APPROVED	D3196	SHEET 2 OF 3
DATE	TITLE	SCALE	
06.10.31	BAR	1:5	

DART Aerospace LTD
HAWKESBURY, ONTARIO, CANADA



D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 30602

RELEASED
06-10-31

DART

DESIGN	QC	DRAWN BY	AS	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.10.31	TITLE	BAR	REV. C
				SHEET 3 OF 3
				SCALE 1:5